

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020173**Date Inspected:** 07-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations relative to the work being performed.

OBG Segment Name: 6BW+6CW / OBG Trial Assembly Area

This Caltrans QA inspector observed Flux Cored Arc Welding (FCAW) in progress. Welder is identified as #200676 using WPS-B-T-2233-B-U2-F. The weld is identified as #SP149-001-37 and 38. ZPMC QC inspectors are identified as Mr. Feng Ya Jun and certified welding inspector (CWI), Mr. Li Yang. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 6BW+6CW / OBG Trial Assembly Area

This Caltrans QA inspector observed FCAW in progress. Welder is identified as #067501 using WPS-B-T-2233-B-U2-F. The weld is identified as #BP033-001-20 and 27. ZPMC QC inspectors are identified as Mr. Feng Ya Jun and CWI, Mr. Li Yang. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: West 1 Tower / Heavy Duty Dock

This Caltrans QA inspector observed FCAW in progress. Welder is identified as #053486 using WPS-B-T-2333-TC-P4-F. The weld is identified as #WSD1-SA653D/F-4. ZPMC QC/CWI inspector is identified as Mr. You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment 7CW

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This QA Inspector performed ZPMC Notification of Inspection Request #2468. QA performed preliminary random visual inspection after the grit blast of the internal ceiling from PP53 to PP54 of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection. The following digital pictures illustrate locations where arc strikes were identified for base metal repair and magnetic particle test inspection.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
